

C L A I M S

- Sub. B<sup>3</sup>
1. A method of producing a laminated package with an opening (22) which is sealed by a tear-off strip (24),

characterized by the following steps:

- punching out an opening (22) in a packaging material (1),
- coating the packaging material (1) at least in the area of the opening (22),
- creating a package sheathing (5) from the coated packaging material,
- conveying the package sheathing to a filling machine (6) or to an equipment unit (9') upstream from the filling machine (6), and
- attaching a tear-off strip (24) to the opening (22) in the package sheathing (5) in the filling machine (6) or in the equipment unit (9') upstream from the filling machine (6).

2. A method according to Claim 1,

characterized in that the tear-off strip (24) is mounted on a mandrel (8) of a mandrel wheel (9) or

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by means of an anvil (8a) in the area of a cell chain (11).

3. A method according to Claim 1 or 2,

characterized in that the package sheathing (5) is conveyed to the filling machine (6) in such a way that its opening (22) points outward across the working direction (A) of the filling machine (6).

4. A method according to one of Claims 1 through 3,

characterized in that the package sheathing (5) is rotated about its longitudinal axis by approximately 90° between a magazine (7) for accommodating prefabricated package sheathing (5) on the filling machine (6) and the location (28) where the tear-off strip (24) is attached.

5. A method according to one of Claims 1 through 4,

characterized in that the tear-off strip (24) is applied between the mandrels of a mandrel wheel (9) which is driven in cycles using at least one welding device (23) which is inserted between two mandrels and is retracted again after the tear-off strip (24) has been welded.

6. A method of producing a laminated package with an opening (22) which is sealed by a tear-off strip (24),

characterized by the following steps:

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- punching out an opening in a packaging material,
- coating the packaging material at least in the area of the opening,
- applying a tear-off strip or a pouring element to the opening in the packaging material in the filling machine or in an equipment unit upstream from the filling machine,
- creating a package sheathing from the coated packaging material, and
- conveying the package sheathing to a filling machine or to an equipment unit upstream from the filling machine.

7. A method according to one of Claims 1 through 6, characterized in that the tear-off strip (24) or the pouring element is applied upstream from an aseptic station (28) of the filling machine (6).
8. A method according to one of Claims 1 through 7, characterized in that the tear-off strip (24) or the pouring element is attached by welding.

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9. A method according to Claim 8,  
characterized in that the tear-off strip (24) or the  
pouring element is attached by ultrasonic welding or  
high-frequency welding.
10. A method according to one of Claims 1 through 7,  
characterized in that the tear-off strip (24) or the  
pouring element is attached by gluing.
11. A method according to one of Claims 1 through 10,  
characterized in that the tear-off strip (24) or the  
pouring element is pulled off from a supply roll  
(25) having a plurality of tear-off strips.
12. A method according to Claim 11,  
characterized in that the tear-off strip (24) or the  
pouring element is conveyed by means of feed rollers  
(26) and is detached from the supply roll (25) by a  
cutting device (27).
13. A method according to one of Claims 1 through 12,  
characterized in that the tear-off strip (24)  
consists of a tear-resistant aluminum strip.
14. A method according to one of Claims 1 through 13,  
characterized in that the filling machine (6) is a  
filling machine having multiple lanes.

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15. A laminated package with an opening (22) which is sealed by a tear-off strip (24),

characterized in that the package is produced by the method according to one of Claims 1 through 14.

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